

Fig. 1

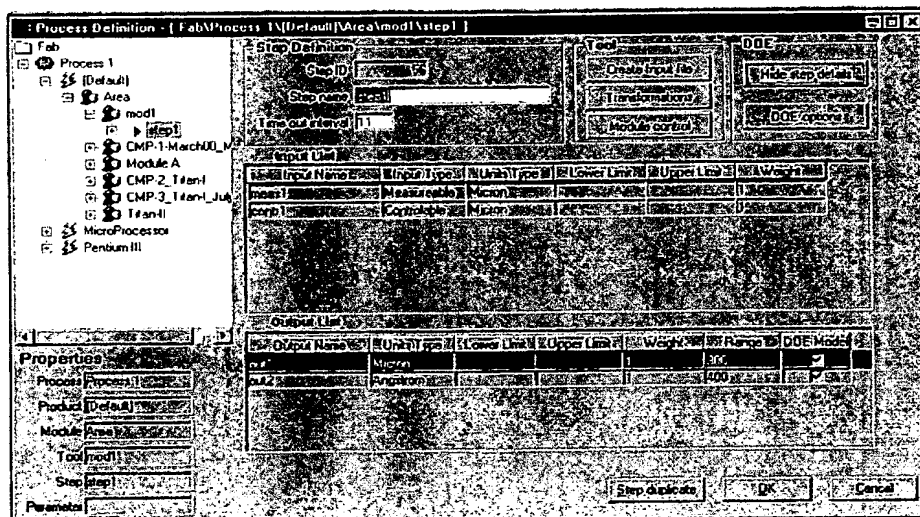


Fig. 2

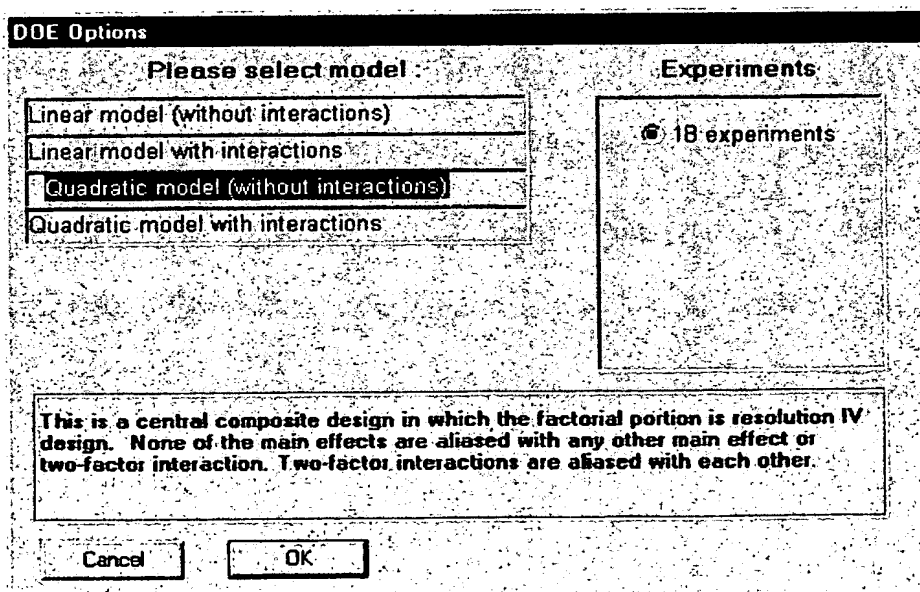


Fig. 3

09745014-051101

DOE Table

Select from File list:

	Pad Life2	Thickness Out	Polish time2	Platen Speed	Thick. Out2	Uniform-3mm	Uniformity-2
8	84000.00	8000.00	75.00	145.00			
9	0	7000.00	63.00	110.00			
10	84000.00	7000.00	63.00	110.00			
11	42000.00	6000.00	63.00	110.00			
12	42000.00	8000.00	63.00	110.00			
13	42000.00	7000.00	50.00	110.00			
14	42000.00	7000.00	75.00	110.00			
15	42000.00	7000.00	63.00	75.00			
16	42000.00	7000.00	63.00	145.00			
17	42000.00	7000.00	63.00	110.00			
18	42000.00	7000.00	63.00	110.00			

Delete row Print Save Reg Analyze

Fig. 4

From  
Fig. 1

Regression  
to Build Formula

Build Results  
database

Start POEM

Build Vectors  
of Input  
Space

Associate each  
Vector With  
Result

Place Vectors &  
Results in POEM  
Lookup Table

Control Process  
Using Lookup Table

Update Lookup Table  
With Actual Results

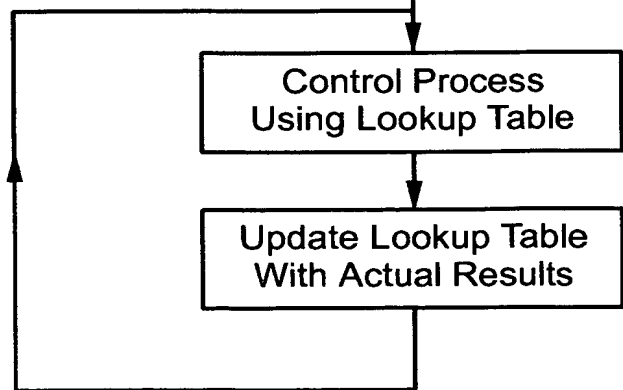


Fig. 5

09746014-051101

09746014-05101  
T01F50"41094260

**Formula 1**

2.3709E+05 - 8.3456E+01\*18 - 6.2948E+02\*17 - 2.5349E+02\*16 - 3.4396E+04\*15 - 6.1168E-01\*18\*17 + 2.5208E-01\*18\*16 + 5.5903E+01\*18\*15 + 8.7573E-01\*17\*16 + 1.2173E+02\*17\*15 - 3.7708E+01\*16\*15

Do you want to save this formula in the .txt file?

Fig. 6

**ConSyst Setup**

Select output for analysis: **Output\_A\_1**

ANOVA Source	Sum of Squares	DF	Mean Square	F Value	Prob > F
Model	5.4015224E+07	10	5.4015224E+06	1.1067191E+00	< 0.0001
Curvature	3.6337890E+04	1	3.6337890E+04	1.5441975E-02	9.0459800E-01
Error	2.9294131E+07	6	4.8823555E+06		
Cor Total	8.3335694E+07	17			

**SUMMARY of FIT**

Root MSE: 2.2092280E+03    R-Squared: 0.648  
 Dep Mean: 9.3305556E+03    Adj R-Squared: 0.146  
 CV: 2.3677347E+01

Factor Name	Coef Estimate	Std Error	t-Statistic	p-Value
Input_A_4	2.3709E+05	4.1103E+02	2.0304E-01	< 0.0001
Input_A_3	-8.3456E+01	4.7669E+02	-1.3205E-01	< 0.0001
Input_A_2	-6.2948E+02	2.4128E+02	-1.0506E-01	< 0.0001
Input_A_1	-2.5349E+02	4.0894E+04	-8.4109E-01	< 0.0001

	Actual Value	Predicted Value	Residual	Student Residual	User Defined Order
13	1.0000000E+04	8.5743056E+03	1.4256944E+03	1.2332798E+00	13
14	9.0000000E+03	9.9618056E+03	-9.6180556E+02	-8.3199832E-01	14
15	1.1000000E+04	1.1211806E+04	-2.1180556E+02	-1.8321984E-01	15
16	1.1000000E+04	1.1368056E+04	-3.6805556E+02	-2.9134959E-01	16
17	1.0000000E+04	9.3305556E+03	6.6944444E+02	3.3678991E-01	17
18	9.0000000E+03	9.3305556E+03	-3.3055556E+02	-1.6629879E-01	18
Average:		-8.16524130E-11	-6.81447550E-03		

**Diagnostics**

Fig. 7

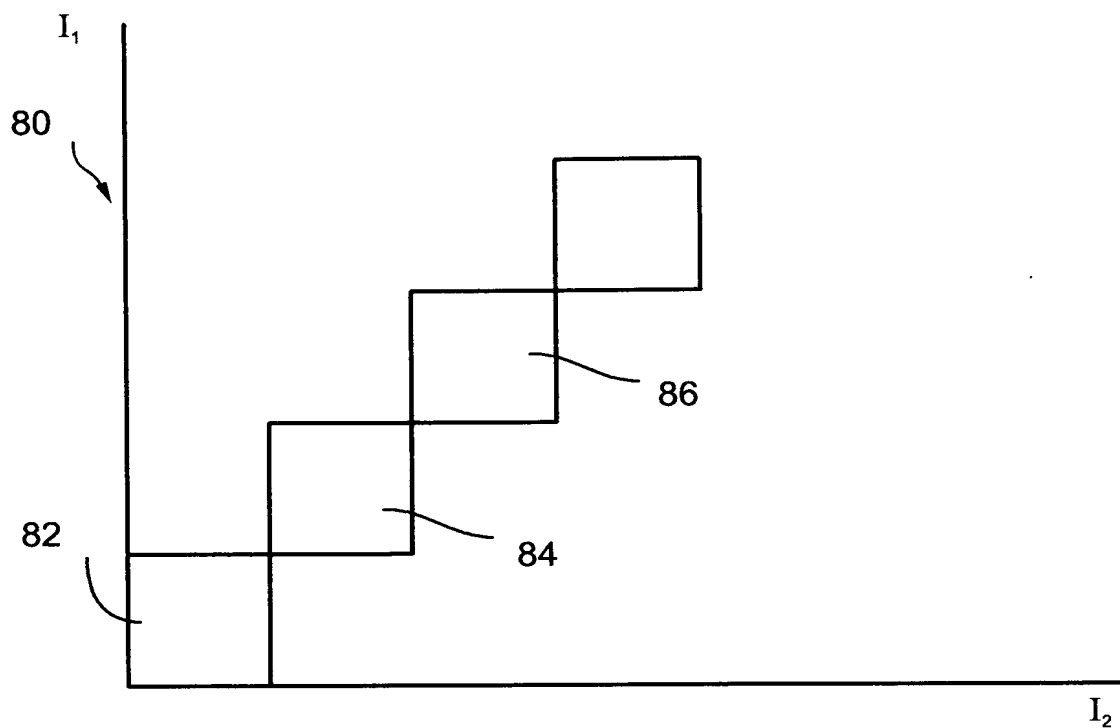


Fig. 8

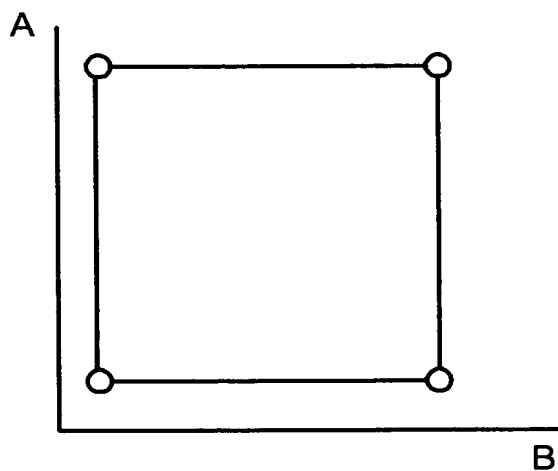


Fig. 9

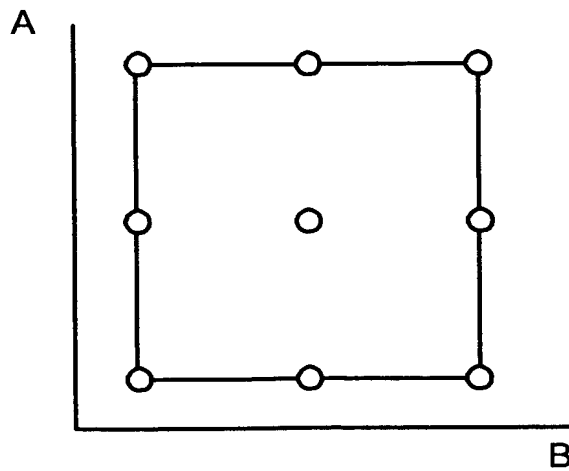


Fig. 10

Fig. 11

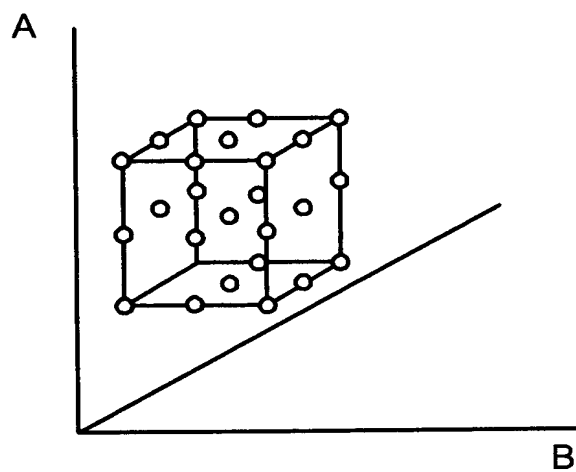


Fig. 12

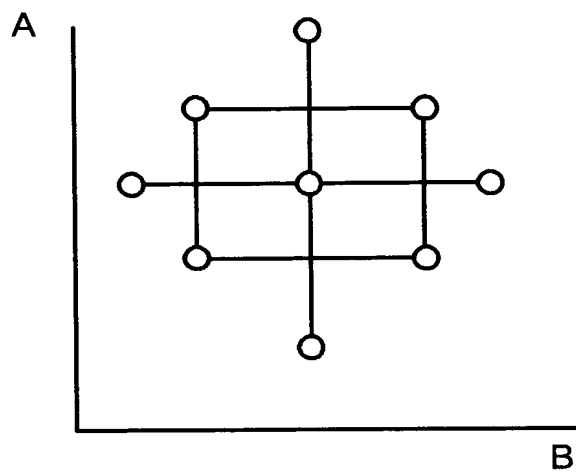


Fig. 13

